

Date: Monday, 10/23/2006 12:03:21 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206B FWD X-TUBE
Job Number : 29101	
Estimate Number : 12346	
P.O. Number : <i>N/A</i>	Part Number : D206667101
This Issue : 10/23/2006 S.O. No. : <i>N/A</i>	Drawing Number : D206-667-141REV B
Prsht Rev. : <i>NC</i>	Project Number : N/A
First Issue : <i>HA</i> Type : LANDING GEAR	Drawing Revision : B
Previous Run : 29100	Material : <i>N/A</i>
Written By : <i>HA</i>	Due Date : 11/20/2006 Qty: 1 Um: Each
Checked & Approved By : <i>HA</i> <i>06 10 23</i>	
Comment : Est Rev: 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-101 CHG002

2.0

D6001105

Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D6001-105	Crosstube	<i>25661</i>

Check OD = 2.250"; ID = 1.874"

*BC 06.10.26*

1

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA083

2-Turn first side as per Folio FA083

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141.

*BC 06.10.26*

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*BC 06.10.26*

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 29101

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA083,

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141.

3-Polish entire outside surface of crosstube

156 6-12-7 ①

4-Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-141

Inside of Cuff(Donot engrave on outside of tube)

BG 06-10-26

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BG 06-10-26

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06/10/27

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DP/JN 6-12-7

9.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-141 using CNC bender program 206B-fw and Folio FT

DP 7-1-22

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

0701-25 ①

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill all (3) top holes.

FT 0701-26

W/O:		- WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206B FWD X-TUBE

Job Number: 29101

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Drill & ream holes as per Dwg D206-667-141 using drill Jig DT8575 & DT8576. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-141. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-141.

Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C/sink holes as per Dwg D206-667-141. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141

ET  
07-01-26

1/M 07-01-26

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MC 107-01-26

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

207-02-06 ①

107/04/26

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

207-02-06 ①

107/04/26

15.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038 Or

Issue P/O: ~~3647~~ LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

3825

CO 7/05/24 ①  
CO 7/04/26 ①

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

CO 7/07/31 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206B FWD X-TUBE

Job Number: 29101

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC6

DIMENSIONAL CHECK



*207-05-31 @*



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

18.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

*RT 07-06-04*

19.0

QC14

Inspect Spray Paint



*207-06-05 @*



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

20.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip

*32020*

*RT 07 06-26*

21.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

*30449*

*RT 07-05-30*

22.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

*29852*

*RT 07-05-30*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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Drawing Name: 206B FWD X-TUBE

Job Number: 29101

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

28482

RT 07-06-26

24.0

MS20601AD4W8



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

102850

RT 07 05-30

25.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

102712

RT 07-06-26

26.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-141. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-141. Touch-up rivet heads with Imron paint.

RT 0706-26

RT 07 05 30

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 29101

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M102115

30.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M103446

31.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

10 AN5-7A

Bolt

M100826

32.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt

M102473

33.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M103694

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-101

Location: Room C

PPP Rev: 7/6/26 S9

7/6/26 S9 EP 07/06/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 9/26/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 29101

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

207106/27

Job Completion



u 07-06-27

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

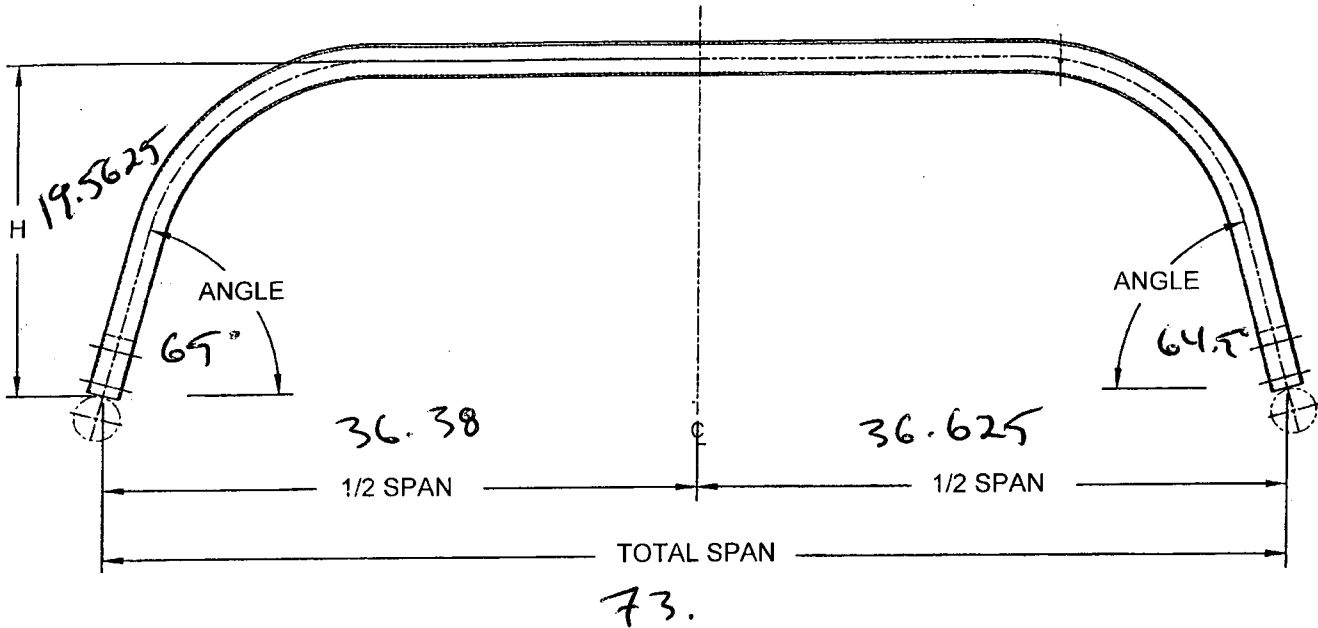
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Crosstube Bend Dimension Sheet



PART NUMBER: D206 667 101  
 BATCH NUMBER: 29101  
 DRAWING: D206 667 141 REVISION: B  
 H: 19.54  
 1/2 SPAN: 36.6  
 TOTAL SPAN: 73.2  
 ANGLE: 65°

Fits table sig  
 quit well. 36.38 is  
 slightly in on the table sig.  
 Acceptable

QC 15: [Signature]  
 DATE: 07-01-25  
 QTY: 1

**DART**

DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-141	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05.07.26UNDER REVIEW  
06/08.10/PH  
re-run detail F  
06-10-23  
PH

Qty	Part Number	Description
X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
1	D6001-105	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

**GENERAL NOTES:**

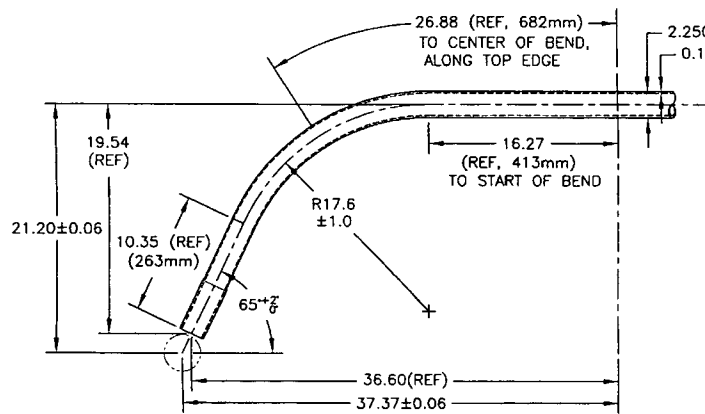
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105  
FINISHED LENGTH = 93.18±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29101

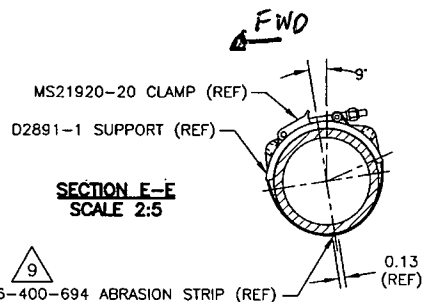
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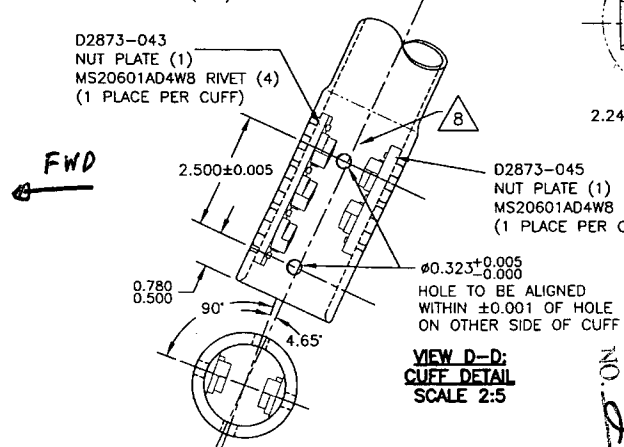




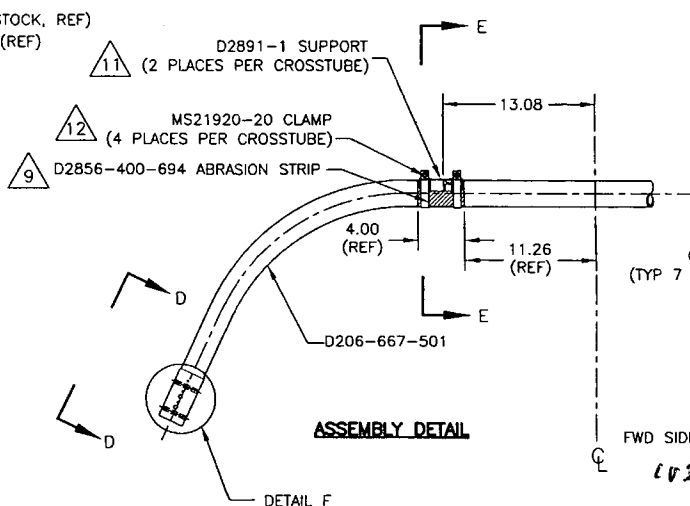
**BENDING DETAIL 6**



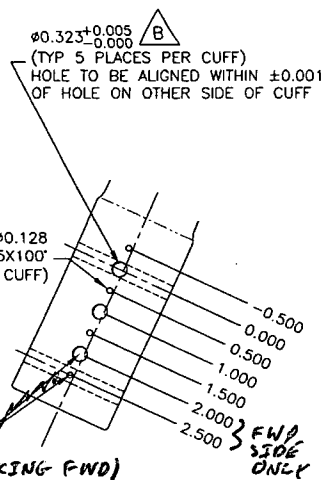
**SECTION E-E SCALE 2:5**



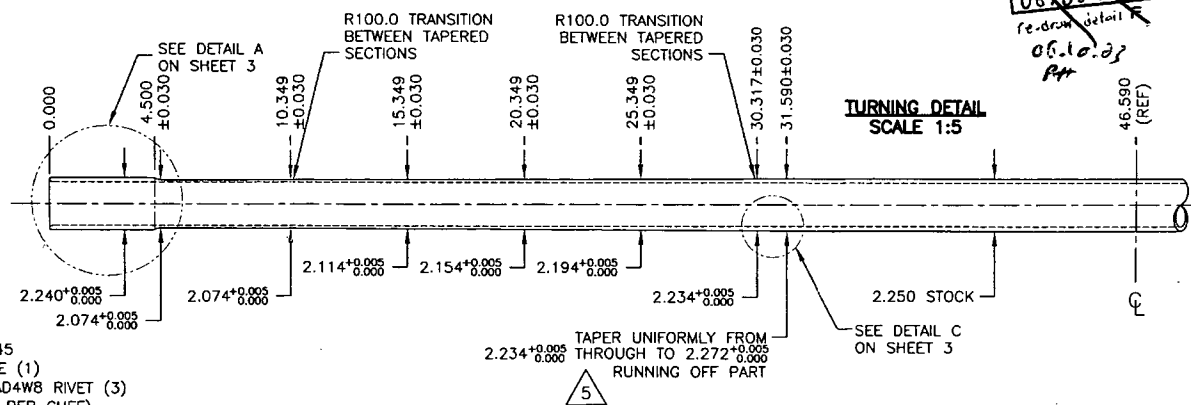
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**ASSEMBLY DETAIL**



**DETAIL F SCALE 2:5**



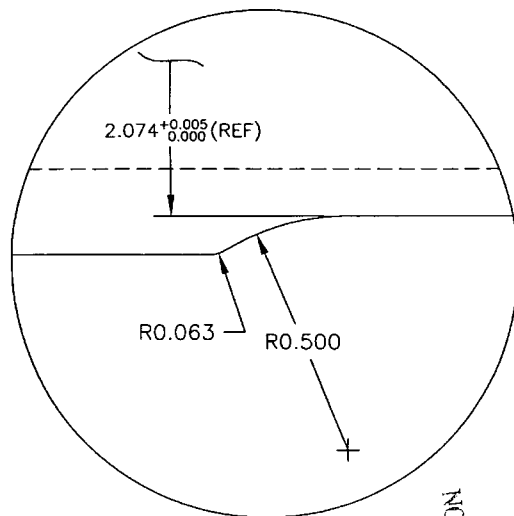
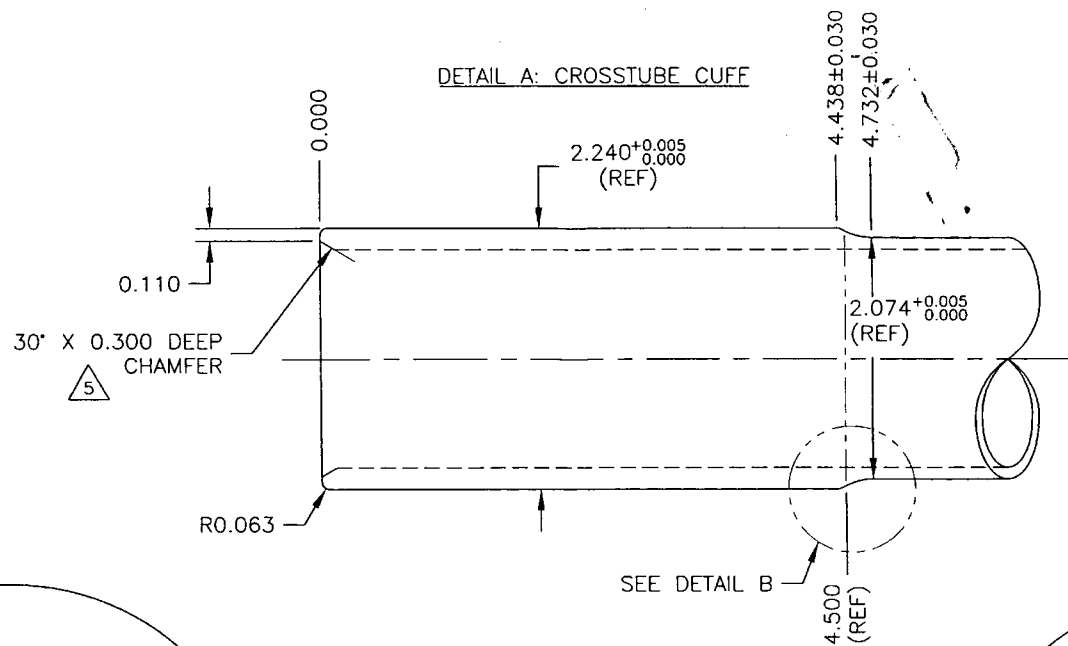
**TURNING DETAIL SCALE 1:5**

**UNDER REVIEW**  
06.08.10 PH  
re-draw detail F  
06.10.03  
PH

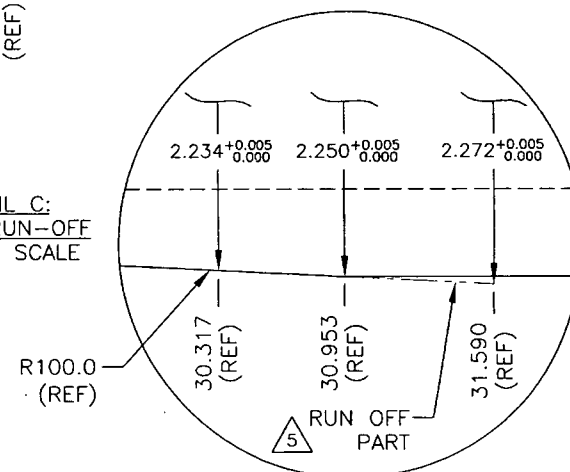
05.07.26

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED DS	APPROVED DS	DRAWING NO. D206-667-141	REV. B SHEET 2 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD)		SCALE 1:10	

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 24101



DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



**UNDER REVIEW**  
06.07.10  
re. dim detail F  
06.10.23

05.07.26

NO. 29101  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

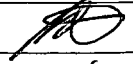
COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN	PH	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. B
		DATE	05.07.26			D206-667-141	SHEET 3 OF 3
						TITLE	SCALE
						CROSSTUBE ASS'Y (206B HIGH FWD)	1:1

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	29101
<b>Description:</b> Crosstube Assembly (206B High Fwd)	<b>Part Number:</b>	D206-667-141
<b>Inspection Dwg:</b> D206-667-141 <b>Rev:</b> B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.243	✓			
	2.074	+0.005/-0.000	2.079	✓			
	2.074	+0.005/-0.000	2.079	✓			
	2.114	+0.005/-0.000	2.119	✓			
	2.154	+0.005/-0.000	2.158	✓			
	2.194	+0.005/-0.000	2.198	✓			
	2.234	+0.005/-0.000	2.237	✓			
	0.110	+/-0.010	.110	✓			
	0.300 x 30°	+/-0.010	.300	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.438	✓			
SIDE B	2.240	+0.005/-0.000	2.243	✓			
	2.074	+0.005/-0.000	2.079	✓			
	2.074	+0.005/-0.000	2.079	✓			
	2.114	+0.005/-0.000	2.118	✓			
	2.154	+0.005/-0.000	2.158	✓			
	2.194	+0.005/-0.000	2.197	✓			
	2.234	+0.005/-0.000	2.237	✓			
	0.110	+/-0.010	.110	✓			
	0.300 x 30°	+/-0.010	.300	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.438	✓			
	93.18	+/-0.020	93.18	✓			

<b>Measured by:</b>	BC	<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06.10.26	<b>Date:</b>	06/10/27	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.24	New Issue (P/O D206-667-101)	KJ/JLM	



**Hea hAir**

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 35707

A.M.O. Number: 46/90

**NON-DESTRUCTIVE TESTING REPORT****AIRCRAFT / COMPONENT INFORMATION**

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

**INSPECTION REQUIREMENTS**

Carry out FPI of (10) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (4) P/N D206-667-101 S/N's B29099, B28680, B29101 and B26864.

Qty (4) P/N D206-667-201 S/N's B30316, B30319, B29098 and B29096.

Qty (2) P/N D407-667-205 S/N's B26323 and B28983.

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT**INSPECTION REPORT**

Fluorescent penetrant inspection was performed in accordance with the above requirements on (10) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

(10) cross tubes inspected. ~~(6)~~ PASSED / (4) FAILED.

Details: Failed S/N's B29099, B28680, B29101 and B29098.  
- tubes are marked at locations requiring rework.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE February 12, 2007

INSPECTION  
STAMP(S) **CUSTOMER INFORMATION**

CUSTOMER:

Dart Aerospace

P.O. NUMBER

PO 00003046

ADDRESS:

CONTACT NAME: Linda Lacelle

LABOUR

MATERIALS

TRAVEL EXPENSES

HOTEL EXPENSES

①

②

③

④

F. (613) 632-1053

\$

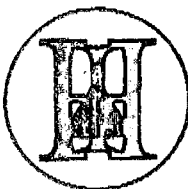
GST

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

**HeathAir**

INTERNATIONAL (1991) INC.

681 Ave. Lapine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36257

A.M.O. Number: 46/90

**NON-DESTRUCTIVE TESTING REPORT****AIRCRAFT / COMPONENT INFORMATION**

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

**INSPECTION REQUIREMENTS**

Carry out FPI of (13) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D058-676-101 S/N B30250.

Qty(2) P/N D206-667-103 S/N's B30429 and B28979.

Qty (1) P/N D206-667-203 S/N B29635.

Qty(1) P/N D206-667-201 S/N B29098.

Qty (2) P/N D412-664-245 S/N's B31600 and B31598.

Qty (2) P/N D412-664-145 S/N's B31434 and B31152.

Qty (4) P/N D206-667-101 S/N's B30438, B28680, B29101 and B29099.

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT**INSPECTION REPORT**

Fluorescent penetrant inspection was performed in accordance with the above requirements on (13) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

(13) cross tubes inspected. (10) PASSED / (3) FAILED.

Note: Failed items were serial numbers from above - B30250, B28680 and B29101.  
- tubes were marked in areas requiring rework.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

DATE

April 27, 2007.

INSPECTION  
STAMP(S)

CUSTOMER: Dart Aerospace

P.O. NUMBER

PO 00003644

ADDRESS: fax to 613-632-1053

CONTACT NAME: Linda Lacelle

LABOUR

MATERIALS

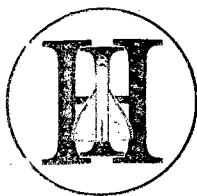
TRAVEL EXPENSES

HOTEL EXPENSES

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36419

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of seven (7) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (1) P/N D212-664-201 S/N B31360  
Qty. (1) P/N D058-676-101 S/N B30250  
Qty. (2) P/N D206-667-101 S/N's B29101 & B28680  
Qty. (3) P/N D412-664-145 S/N's B31396, B31594 & B31595

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on seven (7) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive) Ardrex 970P25E Batch #04B503.

Five (5) cross tubes PASSED inspection and two (2) cross tubes FAILED inspection (P/N D212-664-201 S/N B31360 & P/N D058-676-101 S/N B30250).

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE May 31, 2007

INSPECTION STAMP(S) Not Required

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

3825

ADDRESS:

CONTACT NAME:

AE OUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$

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